

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT
Job Number	: 35691		
Estimate Number	: 10546		
P.O. Number	: N/A	Part Number	: D30631
This Issue	: 11/13/2007 S.O. No. : N/A	Drawing Number	: D3063 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11/13/2007 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 30892	Material	: N/A
Written By	: <u>10/07/11/13</u>	Due Date	: 11/20/2007
Checked & Approved By	: <u>10/07/11/13</u>	Qty:	80 Um: Each
Comment	: Est:C 02.10.04 Re-format; Blank size change KJ		

Job Number:

1.0	M6061T6B0625X02500	6061-T6 Bar .625" x 2.5"
-----	--------------------	--------------------------

Comment: Qty.: 0.3588 f(s)/Unit Total : 28.7028 f(s)

6061-T6 Bar .625" x 2.5"

Material 6061-T6 (QQ-A-200/8 or QQ-A-225/8 or QQ-A-250/11) (M6061T6B0.625x2.500 or

M6061T6S.625)

Batch: 7106292

20

SHEAR

SHEAR

Comment: SHEAR

Cut blanks 4.000" x 2.500" x 0.625" thick

30

HAAS1

HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio FA175 and Dwg D3063

2-Deburr & Tumble

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK

Comment: SECOND CHECK

6.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: in A

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/12/12

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/03	3.0	Pick wrong tools for corner .125 cause The Radius is Too deep. R.E: Human ERROR and folio not clear.	<i>[Signature]</i> Residual 2	Scrap and destroy and replace the part only to	DF 07/12/03	<i>[Signature]</i> 7/12/06	<i>[Signature]</i> Residual 2	<i>[Signature]</i> 07/12/06

NOTE: Date & initial all entries

Date: Tuesday, 11/13/2007 1:33:35 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 35691

Part Number: D30631

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



83

Comment: FINAL INSPECTION/W/O RELEASE

For 12/12

Job Completion



min 2007/12/11

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35691
Description: Support		Part Number:	D3063-1
Inspection Dwg: D3063 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.063	+/-0.010	R.063	✓			
R0.125	+/-0.010	.125				
0.566	+/-0.010	.564	✓			
0.375	+/-0.010	.370	✓			
Ø0.257	+0.005/-0.000	.258	✓			
R0.375	+/-0.010	R.0375	✓			
0.125	+/-0.010	.125	✓			
2.293	+/-0.005	2.292	✓			
0.490	+/-0.010	.493	✓			
0.188	+/-0.010	.189	✓			
2.960	+/-0.010	2.967	✓			

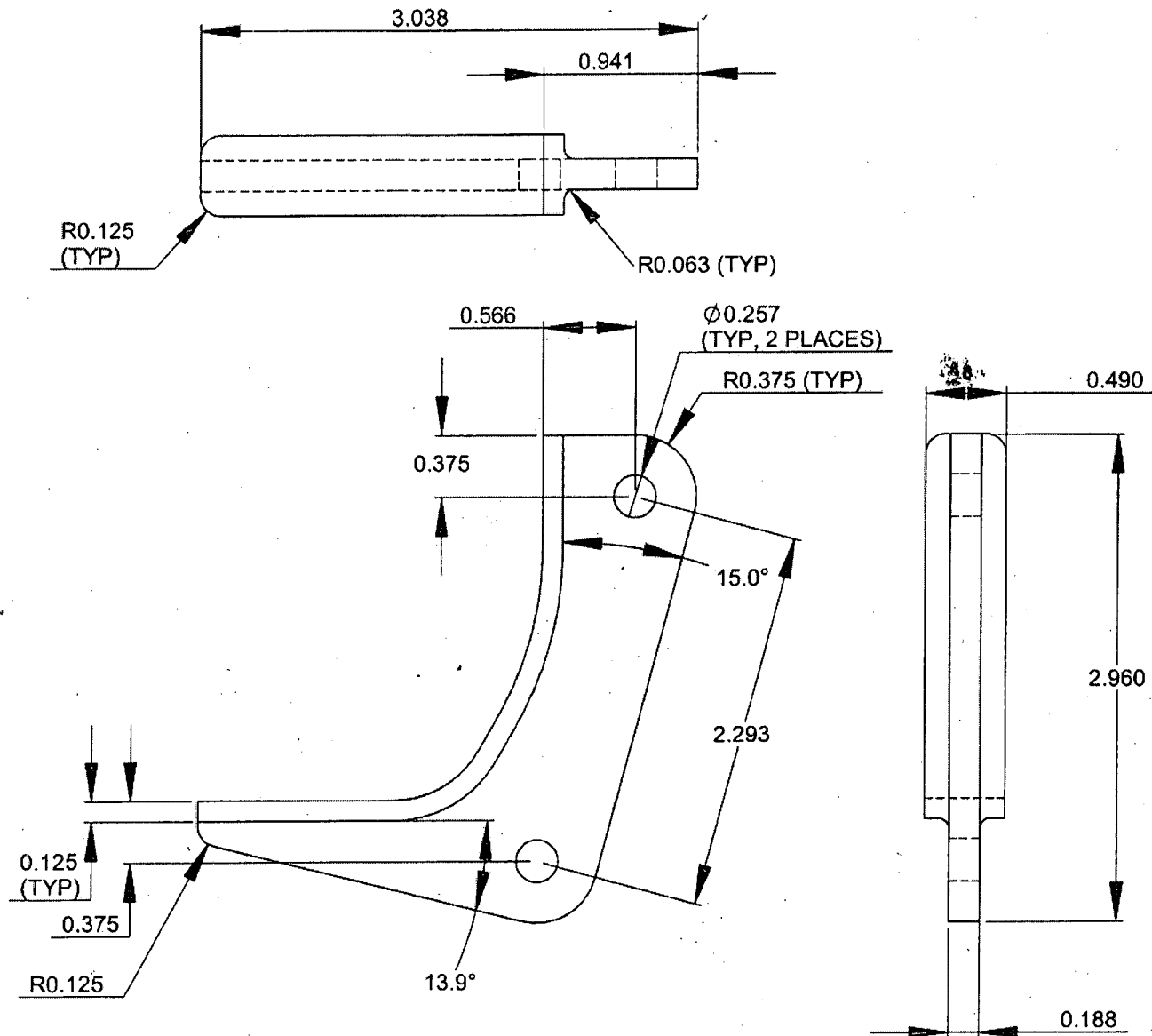
Measured by: <u>RF</u>	Audited by: <u>IL</u>	Prototype Approval:	N/A
Date: <u>07/12/03</u>	Date: <u>07/12/03</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF <u>RF</u>	<u>IL</u>



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3063	REV. A SHEET 1 OF 1
DATE 02.09.10	TITLE SUPPORT		SCALE 1:1
A	02.09.10	NEW ISSUE	

RELEASED
02.09.20



D3063-1 SUPPORT

- 1) MACHINE PER DWG FILE "D3063-1.SLDPRJT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8 OR QQ-A-250/11)
(REF DART SPEC M6061T6B OR M6061T6S)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **35691**

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